Dart Aerospace Ltd. Tuesday, 15/07/2008 9:14:15 AM Julie Lecocq User: **Process Sheet Drawing Name** : TUBE : CC-DAR01 Dart Aerospace Ltd. Customer **Job Number** : 40480 **Estimate Number** : 13337 Part Number : D37623 P.O. Number : D3762 REVA S.O. No. : **Drawing Number** : 15/07/2008 This Issue **Project Number** : N/A : NC Prsht Rev. : MACHINED PARTS : 11 Type **Drawing Revision** First Issue : 39470 Material Previous Run 4 Um: Each **Due Date** : 22/07/2008 Qty: Written By **Checked & Approved By** DD verified by:ec Comment : Est Rev:A new issue Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: 6061-T6 Round Bar 1.250 1.0 M6061T6R1250 0.4536 f(s) Comment: Qty.: 0.1134 f(s)/Unit Total: 6061-T6 Round Bar 1.250 Batch: 18 29 T DOOSAN LATHE 2.0 DOOSAN LATHE Comment: Doosan Lathe 1- Turn as per Folio FA749 Rev: 2-Deburr per dwg D3762 INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 4.0 Comment: SECOND CHECK

Comment: PACKAGING RESOURCE #1

PACKAGING 1

Identify and Stock

Location:\_\_\_\_\_ *\$\frac{1}{1}* 



PACKAGING RESOURCE #1

5.0

Dart Ae	rospace Li	id .									
W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Dort No.		DAD #1	Fault Catagony	NCD	Voc. N	n DOA:	Data				
rait No	•	PAR#:	Fault Category:			Closed:					
NCR:		V	VORK ORDER NON-CONF	ORMANCE	(NCR)						
DATE	STEP	Description of NC	Corrective Action		Sian &	Verification	Approval	Approval			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	1	Corrective Action Section B				A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

Date:

Tuesday, 15/07/2008 9:14:15 AM

User: Julie Lecocq

**Process Sheet** 

**Customer:** CC-DAR01 Dart Aerospace Ltd.

Drawing Name: TUBE

Job Number: 40480

Part Number: D37623

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

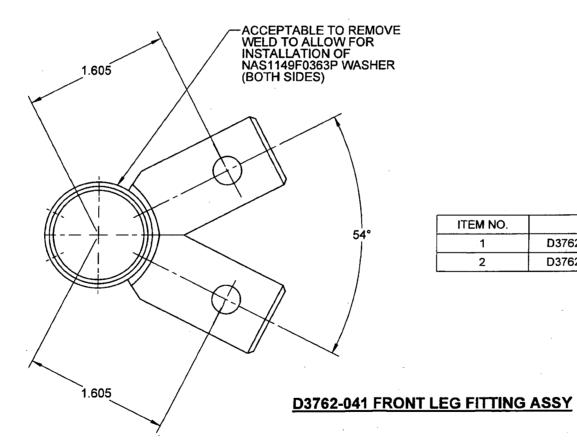
Job Completion

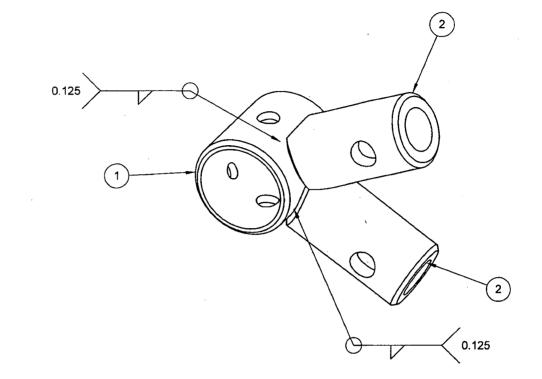


MF 08-08-

Dart Ae	rospace L	.td								
W/O:			WO	RK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	·	PAR #:	PAR #: Fault Category: NC				QA: Date:			
					QA: N	C Close	d:	_ Date: _	· · · · · · · · · · · · · · · · · · ·	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR	)				
DATE	OTED	Description of NC	Corrective Action Section B			Verific	ication	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector	
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NOTE: Date & initial all entries





ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
-1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

SHOP COPY RETURN TO ENCINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WITHOUT NOTICE
WORK ORDER
0. 40480

					110	
Α	NEW IS	SUE	HS	08.06.04		
REV.			DESCRIPTION	BY	DATE	
DESIGN		HS	DART AEROSPAC	CE L	E LTD	
DRAW	N	HS	HAWKESBURY, ONTARIO,			
CHECK	ŒD	PH	DRAWING NO.		REV. A	
MFG. A	PPR.		D3762		SHEET 1 OF	
APPRO	VED	M	TITLE		SCALE	
DE APPR.		-#-	FRONT LEG FITTING		NTS	
DATE	08.0	6.04	COPYRIGHT © 2008 BY DART AER!  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON INOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED	THE EXPRES	S CONDITION THAT IT IS	

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.05 lbs
8) WELD: PER DART QSI 004

8

Ø0.50 THRU 0.06 X 45° CHAMFER BOTH SIDES--0.05 X 45° CHAMFER Ø 0.860<sup>+0.000</sup><sub>-0.010</sub> 1.62 Ø0.323 THRU R0.60-30° - 1.41 1.60 0.55 **D3762-1 FITTING** 

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DESIGN DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA CHECKED POF DRAWING NO. REV. A D3762 MFG. APPR. SHEET 2 OF 3 TITLE **APPROVED** SCALE FRONT LEG FITTING DE APPR.

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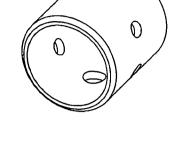
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NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC, M6061T6R)

(OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

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- Ø0.188 THRU (2 PL) Ø1.010<sup>+0.010</sup> -0.000 Ø 1.20 -0.05 X 45° CHAMFER 1.30 Ø 0.257 THRU 0.65



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SUBJECT TO A MENDMENT

## **D3762-3 TUBE**

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R) (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

С

DESIGN	HS	DART AEROSPACE	LTD				
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA					
CHECKED	₽ <del>U</del>	DRAWING NO.	REV. A				
MFG. APPR.		D3762	SHEET 3 OF 3				
APPROVED	JUNA	TITLE	SCALE				
DE APPR.	4	FRONT LEG FITTING	NTS				
DATE 08.0	06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

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					Part Num	her:	
Description:					rait itan		
Inspection Dwg	: Rev:					Pa	ge 1 of 1
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	X	First Artic	le	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method Inspecti		mments
is. 188	+/030	,19					
105 × 450	1-030 × 12	005 445					
1,30	+/030	1.30	,				
65	+1030	.65					
-257	1.005001	1 - 1					
1,010	4.01	1.014					
1,20	+/030	1.260					
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270	1/2	27					
270	1/2	27"					
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Measured by: Audited by: T.F. Prototype Approval:							
Measured by: Audited by: 5.7-  Date: 08/08/01  Date: 08/08/01						Date:	
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Rev Date	Change New Issue					Revised by KJ/JLM	Approved